Punch

# Work Order ID 117824

*May-05-14 11:45:11 AM*

D2565-101
B117824

*117824*



**Item ID:** D2565-101 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Strut

**Start Date:** 5/12/14 **Start Qty:** 6.00 *6*
**Required Date:** 5/12/14 **Req'd Qty:** 6.00 *6*
**Reference:**

**Cust Item ID:**
**Customer:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** MLS **Date:** 14-05-06 **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** / **Revision Nbr** | | | | | | | | | |
| D2565 / Rev E | | | | | | | | | |
| 100 | Punch ends and deburr as per dwg | 0.00 | | | DAS 30 9-89 | 5 | | | 14/06/09 |
| *100* | NC BRAKE | | | | | | | | |
| Brake NC | **Memo** | 0.00 | | | | | | | |
| Brake NC | Punch as per Dwg D2565 using DT 8313 | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
| *110* | Small Fab | | | | | 5 | | | 14/06/23 DAS 36 9-89 |
| Small Fab | **Memo** | 0.00 | | | | | | | |
| Small Fab | Drill hole open to .316 Ø as per Dwg D2565 (one end only)<br>Deburr | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | 5 | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

SH 14/06/23

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

**Item ID:** D2565-101 **Accept** *N9000040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Strut

**Start Date:** 5/12/14 **Start Qty:** 6.00 *6*
**Required Date:** 5/12/14 **Req'd Qty:** 6.00 *6*
**Reference:**

**Cust Item ID:**
**Customer:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 *130* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.2) per QSI005.4.3-Steel M128959. Memo START TIME: 1:20 OVEN TEMPERATURE: ~~400~~ FINISH TIME: 1:50 | 0.00 0.00 | | | | 50 | 14-6-23. | | DAS 34 9-89 |
| 140 *140* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 5 | | | DAS 27 9-89 14/6/23 |
| 150 *150* Packaging Packaging | Identify as per dwg & Stock Location: ST450 Memo | 0.00 0.00 | | | | 5x | DAS 28 9-89 | JUN 24 2014 | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric
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- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
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- ☐ Burrs
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- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
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- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

**Item ID:** D2565-101 **Accept** *N900040100* **Setup Start** *NS1*
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|---|---|---|---|---|---|---|---|---|---|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | MLJ 14-06-24 | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MF 14-6-24

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

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NCR No. _____

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Large Fab ☐ Composite ☐ Supplier ☐

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| Doc/Data | ☐ | | | | | | | | | |
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| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
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☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

# Picklist Print

*May-05-14 11:45:11 AM*



**Work Order ID:** 117824 *117824*

**Parent Item:** D2565-101 *D2565-101*

**Parent Item Name:** Strut

**Start Date:** 5/12/14 **Required Date:** 5/12/14

**Start Qty:** 6.00 **Required Qty:** 6.00

**Comments:** IPP: F02.04.16Added dwg Rev.C1NG

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304TR0.750W.049 | | Purchased | No | | | 100 | f | 123.7261 | 1.71 | 11 | | | DAS 30 9-89 |
| *M304TR0.750W.049* | | | | | | | | | ** | | | | |

304 RD Tube .750 x .049W

14/06/09

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| MAT017 | 123.7261 | | |
| 122312 | 4.04 | | |
| 124768 | 49.27 | | |
| M126183 | 25.4399 | | |
| M128084 | 44.9762 | | |

M129188

13

DQA: _____ Date: _____

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| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

# DART AEROSPACE LTD

DART AEROSPACE

Description: Studs Work Order: 117824

Inspection Drawing: D256T Rev: E Part Number: ~~117~~ D2565-10(

## INSPECTION SHEET

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 20.52 | +/-.030 | 20.52 | ✓ | | I | SB-5 |
| 19.72 | +/-.030 | 19.72 | ✓ | | I | SB-5 |
| Ø.316 | +/-.005 | Ø.316 | ✓ | | I | SB-11 |

| Measured by: | Checked By: | QC inspector: | Engineering Approval (*if necessary*) |
|---|---|---|---|
| DAS 30 9-89 | DAS 36 9-89 | | |
| Date 14/06/09 | Date 14/06/09 | Date 14/6/23 | Date |